



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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SWA6A-200
Job Sheet 189833



Part No: SWA6A-200

Job Qty: 12 pcs

Part Name: Upper End



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/31/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 2/15/19

Description:

Type: SOLD

Note: DWG SWA6A-200 Rev8 IPP Rev A 17.11.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs	2/15/19	2/15/19	0.00	1.20	Bandsaw - 1		3/12
110	NLX 2500SY - B4B	12 pcs	2/15/19	2/15/19	0.00	12.00	NLX 2500SY - 1 - B4B		
120	QC 2	12 pcs	2/15/19	2/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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CANADA
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Container No: S159506



Part: SWA6A-200

Job No: 189833

Serial No/Batch: S159506

Revision: 8

Inspector:

Exp Date:

Instructions:

Date: 03/06/19

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				QC 2 - 8	
122 NV5000 - 1 - B4B	12 pcs	2/15/19	0.00 12.00	NV5000 - 1 - B4B	
				NV5000 - 2 - B4B	3.0.0.
124 QC 2	12 pcs	2/15/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	3.0.0. 14-09-11
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 38	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
130 QC 8	12 pcs	2/15/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	8.0 19-03-12
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
140 Packaging 3-1 - Stock - B4B	12 pcs	2/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	

Packaging 3 - 6 - B4B				
Packaging 3 - 7 - B4B	DAS			
Packaging 3 - 8 - B4B	28			
Packaging 3 - 9 - B4B	9-89			
Packaging 3 - 10 - B4B				
Packaging 3 - 11 - B4B				
Packaging 3 - 12 - B4B				
Packaging 3 - 13 - B4B				
Packaging 3 - 14 - B4B				
Packaging 3 - 15 - B4B				
Packaging 3 - 16 - B4B				
Packaging 3 - 17 - B4B				
Packaging 3 - 18 - B4B				
Packaging 3 - 19 - B4B				
Packaging 3 - 20 - B4B				
Packaging 3 - 21 - B4B				
Packaging 3 - 22 - B4B				
Packaging 3 - 23 - B4B				
Packaging 3 - 24 - B4B				
Packaging 3 - 25 - B4B				
Packaging 3 - 26 - B4B				
Packaging 3 - 27 - B4B				
Packaging 3 - 28 - B4B				
Packaging 3 - 29 - B4B				
Packaging 3 - 30 - B4B				
Packaging 3 - 31 - B4B				
Packaging 3 - 32 - B4B				
Packaging 3 - 33 - B4B				
Packaging 3 - 34 - B4B				
Packaging 3 - 35 - B4B				
Packaging 3 - 36 - B4B				
150 QC 21 - SA	12 pcs			
2/15/19	0.00 0.00			
QC 21 - SA - 21				
QC 21 - SA - 70				
Part Op 100 - (Bandsaw) Cut Blanks to 6.16" Descriptions: 110 - NLX (MORI NLX 2500SY LATHE) 1-Machine as per DWG. FB705 FOLIO REV: <u>AA</u> DWG REV: <u>8</u> 2-Deburr ***Machine engrave S/N number and machine engrave UP arrow*** 120 - (QC2- Inspect parts off machine FAI/FAIB) 122 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) 1-Machine as per DWG. FB705 FOLIO REV: <u>AA</u> DWG REV: <u>8</u> 2-Deburr 124 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Identify as per dwg & Stock Location: _____) 150 - (QC21- Final Inspection - Work Order Release)				
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R3.000	17-4 H1150 Round Bar 3.000"	6.1560 ft (.513 ea)	100-Bandsaw - 1	5091273
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-H1150-R3.000	6	17	0
Part Specifications				
Specifications could not be found.				

DAS
70
9-89MAT.
used
P. 787

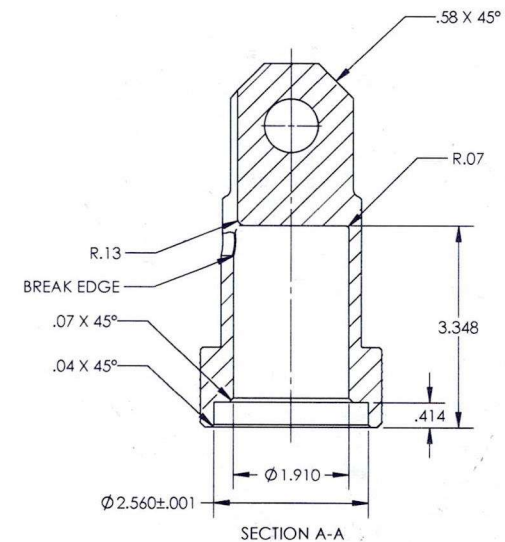
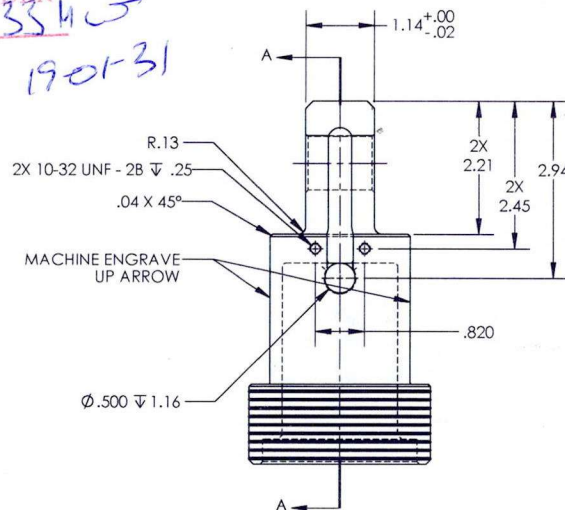
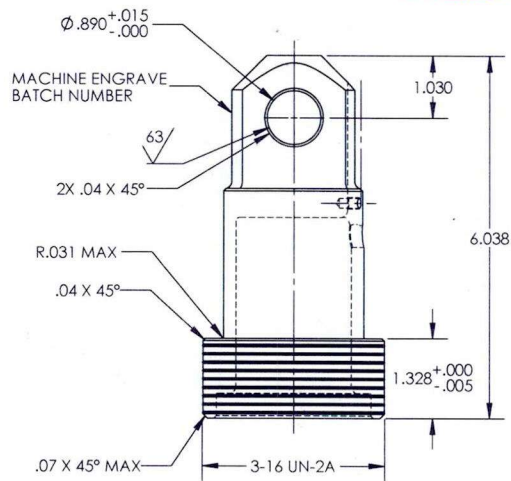
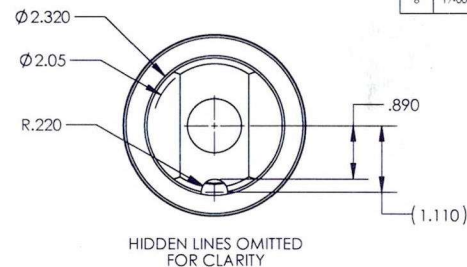
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL APPROVED
4		AS DRAWN BY CANAM.	11/4/2014	JAG
5	14-0207	CH'D CHAMFER ON Ø.890 HOLE WAS 2X .03 X 45° IS 2X .04 X 45°. CH'D DIM WAS Ø2.06 IS Ø2.05.	11/4/2014	RJC JAG
6	15-0092	ADDED MATERIAL H1075.	4/22/2015	RJC JAG
7	15-0271	ADDED UP ARROW NOTE. CH'D DIMS WAS 1.14 IS 1.14 +.00 -.02. WAS 2.21 IS 2X 2.21. DELETED DIMS Ø.90, Ø15/16, R.07. ADDED BREAK EDGE NOTE. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	9/22/2015	DPD JAG
8	17-0064	UPDATED TO NEW STANDARDS. CH'D DIM WAS R.07 IS R.13. WAS 2X 10-32 UNF .25 IS 2X 10-32 UNF .28 .25. ADDED NOTE MACHINE ENGRAVE BATCH NUMBER.	3/17/2017	SM JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1898354
190131



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA6A-200	1	UPPER END	SS 17-4, H1150, H1075	

DART AEROSPACE	
TITLE UPPER END	
DWG NO. SWA6A-200	REV 8
MATERIAL: SS 17-4, H1150, H1075	
FINISH: .XXX ± .005 FRACTIONS ± 1/8	UNLESS OTHERWISE SPECIFIED
FINISH: .XX ± .01 ANGLES ± 5°	1. BREAK ALL SHARP EDGES
FINISH: .X ± .1 SURFACES ± 125	2. DIMENSIONAL LIMITS APPLY
DRAWN BY: CANAM	015 X 45° OR .015R
CHECKED: DD 03/17/2017	AFTER PLATING
OPPS APPR: AA 03/20/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 03/29/2017	USED ON MODEL
APPROVED: JAG 04/03/2017	
SCALE: 1:2	DATE: 1/31/2002
SHEET 1 OF 1	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 189 833
Description: UPPER END		Part Number:
Inspection Dwg: SWA6A-200	Rev: 8	Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.890	+0.015 / -0.000	.8935	✓		Vern LPID	
.04 x 45°	±.01 x .5°	.035 x 45°	✓		Rad gauge	
R.031	±.005	.032	✓		Vern LPID	
.04 x 45°	±.01 x .5°	.035 x 45°	✓			
.07 x 45°	±.01 x .5°	.062 x 45°	✓			
3-16 UN-2A						
M3 Ø 2.9936	+/- .0047	2.995	✓			
Wire Ø.040						
DOW Ø 3.0207	±.0028	3.0205	✓			
1.030	±.005	1.0275	✓		Mic LPID	
Ø.038	±.005	Ø.038	✓		H. gauge	
1.328	+0.000 / -0.005	1.326	✓		Vern LPID	
Ø 2.320	±.005	2.320	✓			
Ø 2.05	±.01	2.049	✓			
R.220	±.005	R.218	✓			
.890	±.005	.890	✓			
1.14	+0.00 / -0.02	1.130	✓		Vern LPID	
R.13	±.01	.125	✓		Rad gauge	
10-32 UNF-2B	60 - N/60	60	✓		60/100-0 gauge	
.25	±.01	.25	✓		Vern LPID	
.04 x 45°	±.01 x .5°	.035 x 45°	✓			
Ø.500	±.005	Ø.500	✓			
2.21	±.01	2.213	✓		H. gauge	
2.45	±.01	2.4525	✓			
2.94	±.01	2.940	✓		H.G.	3108
Ø.20	±.005	.203	✓		Vern LPID	
.58 x 45°	±.01 x .5°	.575 x 45°	✓			
R.13	±.01	R.128	✓			
.07 x 45°	±.01 x .5°	.070 x 45°	✓		Vern LPID	

Measured by: JH-03-08	Checked by: DAS 20 080 / B.A.	QC Inspector:
Date: 20.07.19-03-11.	Date: 19-03-11	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

